

## Classifications

DIN 8555

MF 1-GF-300-GP

## Characteristics

Build-up alloy designed for welding in horizontal and vertical-up positions under gas shielding.

Microstructure: Bainite

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 82% + CO<sub>2</sub> 18%

## Field of use

Conveyor chains, sliding metal parts, gear teeth, crane wheels, undercarriage links, shafts, buffer layer prior to hardfacing.

## Typical analysis in %

C	Mn	Si	Cr	Fe
0,25	1,5	0,4	1,4	balance

## Typical mechanical properties

Hardness as welded: 300 HB

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	110-180	20-31	20 max.	12-15
1,6	150-250	20-31	20 max.	15-18